

Date: Friday, 01/08/2008 3:32:35 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	TUBE
<b>Job Number</b> :	40978		
<b>Estimate Number</b> :	13490		
<b>P.O. Number</b> :		<b>Part Number</b> :	D37701
<b>This Issue</b> :	01/08/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3770 REV B
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	40713	<b>Drawing Revision</b> :	B
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>DD08.8.05</u>	<b>Due Date</b> :	21/08/2008
<b>Comment</b> :	Est Rev:A 08-07-21 revB as per dwg DD verified by:EC		

Qty: 50 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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**Comment:** Qty.: 1.1926 f(s)/Unit Total: 59.6295 f(s)  
 6061T6 TUBE (1.00" x 0.65" wall)  
 batch: M108819

mmf 08/08/14

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3770

8-8-12 JD

2-drill holes thru to finish size as per dwg D3770

3- deburr

SAB 08/08/14 mmf 08/08/14

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

mmf 08/08/14

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/08/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3770-1 PAR #: \_\_\_\_\_ Fault Category: Sn/ & med. NCR: Yes ☐ No ☒ DQA: AS Date: 08.08.24  
D3784-041/043/044  
(D412-769-043/044) QA: N/C Closed: D Date: 08/08/25

NCR: <u>40978</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08.08.18</u>	<u>20</u>	<u>1 part is 0.070" too long as the total length.</u>	<u>GS/142</u>	<u>Buff off 0.070" from the identification (4") end.</u>	<u>EG</u> <u>08/08/18</u>	<u>AS</u> <u>08.08.18</u>	<u>GS/142</u>	<u>08.08.18</u>

NOTE: Date & initial all entries

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User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 40978

Part Number: D37701

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



50x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 511

4/8/20

50

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/20 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/08/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

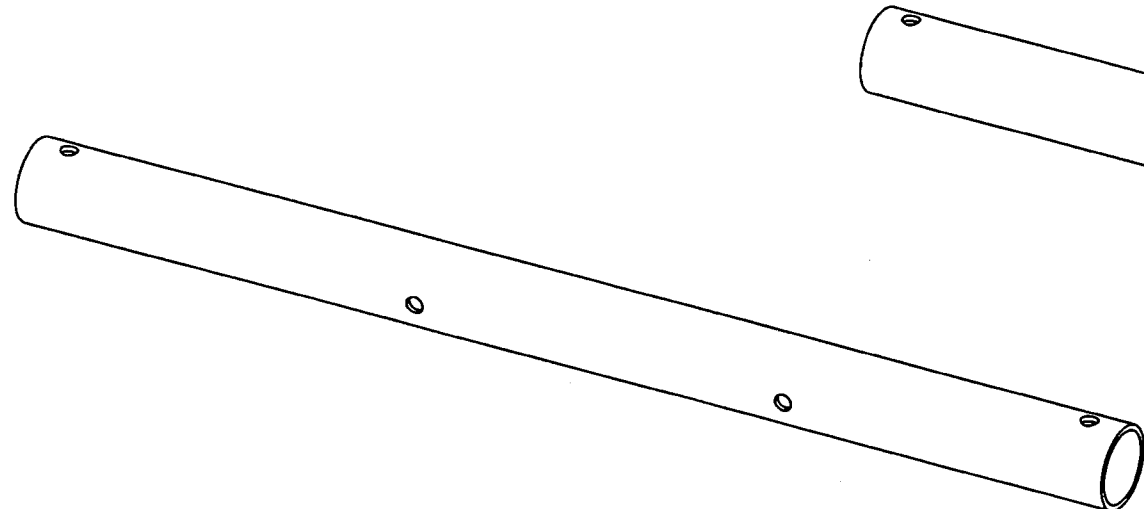
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

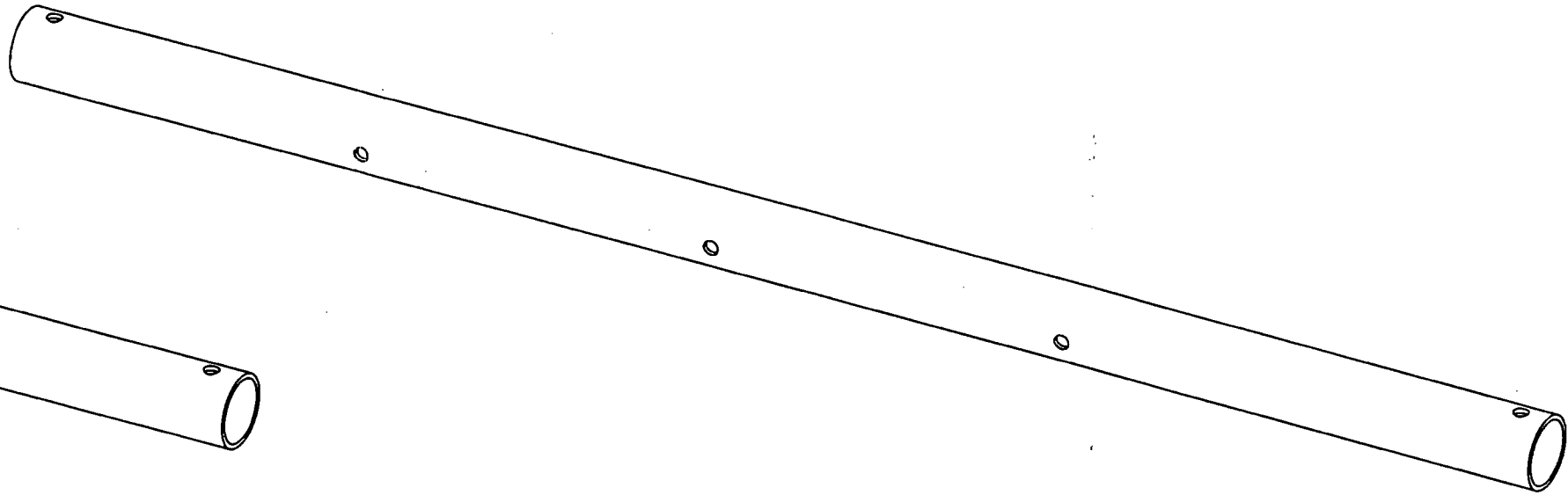
8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
A



**D3770-1 TUBE**



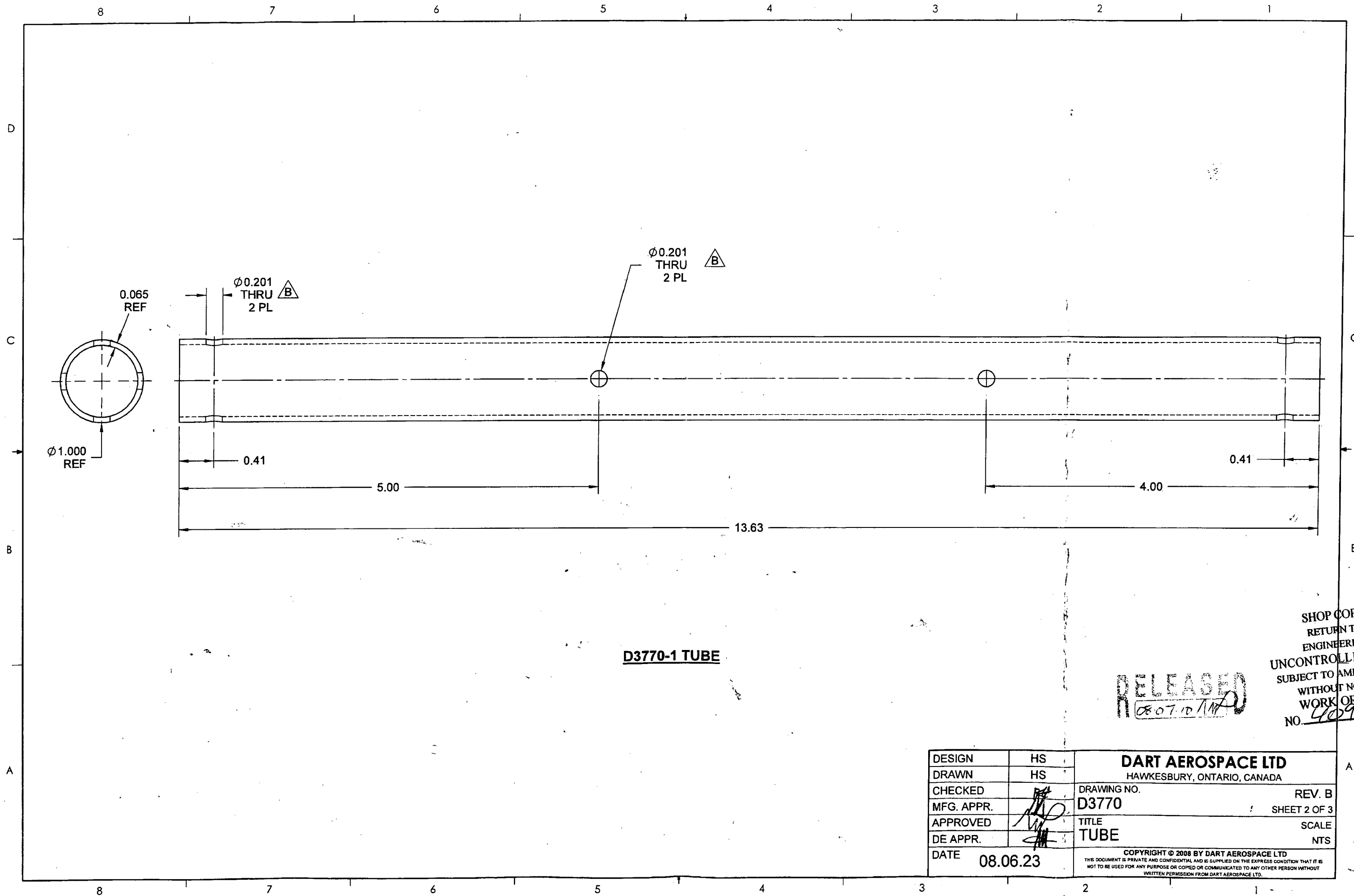
**D3770-3 TUBE**

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WITHOUT NOTICE  
WORK ORDER  
NO. 46928

RELEASED  
08-07-10

- NOTES:  
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: D3770-1, 0.25 lbs  
D3770-3, 0.40 lbs

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3770	SHEET 1 OF 3
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DE APPR.	HS	TUBE	NTS
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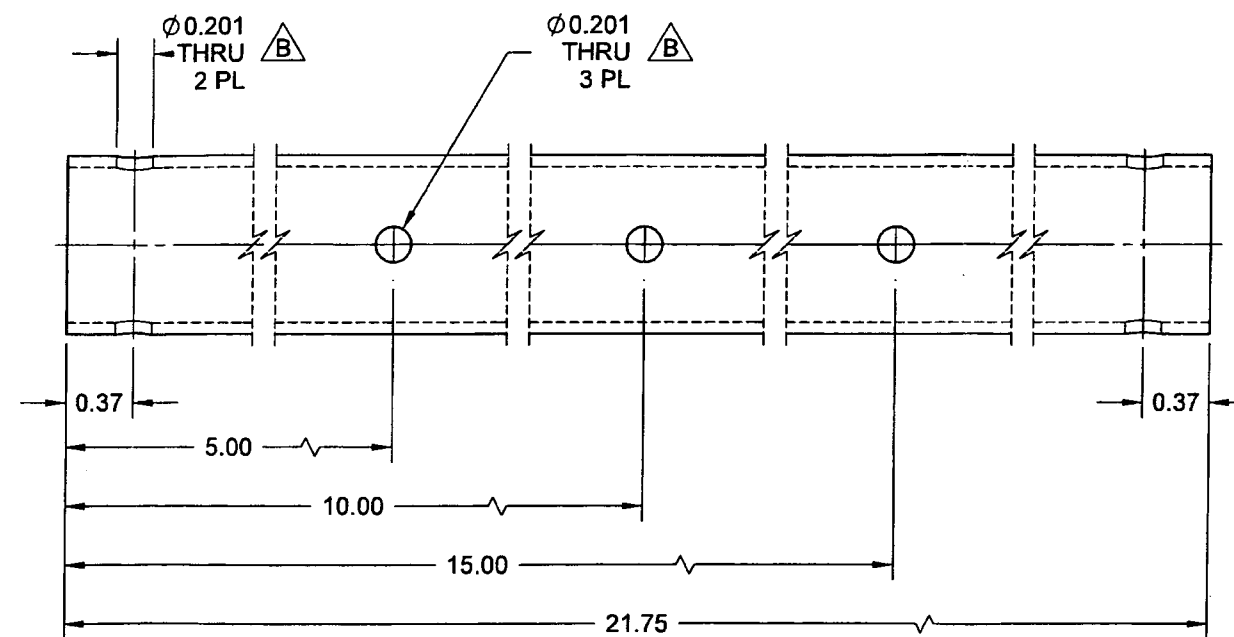
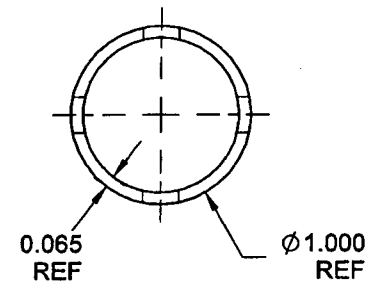


**D3770-1 TUBE**

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**D3770-3 TUBE**

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